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भाग 1 बहिर्वेधित बहुलक जाली से निर्मित बाड़ जाल

**Agro Textiles — Fencing Nets for
Agriculture and Horticulture
Purposes — Specification**

**Part 1 Fencing Nets Made from Extruded
Polymer Mesh**

ICS 59.080.99; 65.020.20

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भारतीय मानक ब्यूरो
BUREAU OF INDIAN STANDARDS
मानक भवन, 9 बहादुरशाह ज़फर मार्ग, नई दिल्ली – 110002
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI-110002
www.bis.gov.in www.standardsbis.in

FOREWORD

This Indian Standard (Part 1) was adopted by the Bureau of Indian Standards, after the draft finalized by the Technical Textiles for Agro-tech Sectional Committee had been approved by the Textile Division Council.

Fencing is being provided to keep the stray animal, unwanted person etc away from agriculture, horticulture, forest or other areas. Additionally, it also provides the aesthetic to the fenced area and also helps in defining boundaries and better organization of any specified place. HDPE fencing nets are a good alternate to galvanized metal fencing and have an advantage of lighter in weight, easy to install and no problem of corrosion.

The composition of the Committee responsible for the formulation of this standard is given in Annex E.

For the purpose of deciding whether a particular requirement of this standard is complied with the final value, observed or calculated, expressing the result of a test or analysis shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

AGRO TEXTILES — FENCING NETS FOR AGRICULTURE AND HORTICULTURE PURPOSES — SPECIFICATION

PART 1 FENCING NETS MADE FROM EXTRUDED POLYMER MESH

1 SCOPE

This standard (Part 1) prescribes constructional and other performance requirements for HDPE fencing nets for agriculture, horticulture, gardens, forestry, animal husbandry, poultry purposes in protecting from stray animals and for restricted entry etc.

2 REFERENCES

The standards listed in Annex A contain provisions which through reference in this text, constitute provision of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated in Annex A.

3 TERMINOLOGY

For the purpose of this standard the definitions given in IS 16366 shall apply.

4 MATERIALS

The high density polyethylene (HDPE) used for manufacture of fencing nets shall conform to the requirements specified in IS 10146. HDPE shall be UV stabilized by incorporating a suitable UV stabilizer so that the finished fencing nets meets the requirements specified in Tables 1, 2 and 3.

5 MANUFACTURE

5.1 Fencing nets shall be manufactured in the following aperture shapes:

- Hexagonal shape (*see* Fig. 1);
- Diamond shape (*see* Fig. 2); and
- Square shape (*see* Fig. 3).

5.2 Colour

The colour of the fencing nets shall be as per the agreement between the buyer and the seller. The colour shall be as specified in the contract or order. In case a sample has been agreed upon and sealed, the supply

shall be made in conformity with the sample in such respects.

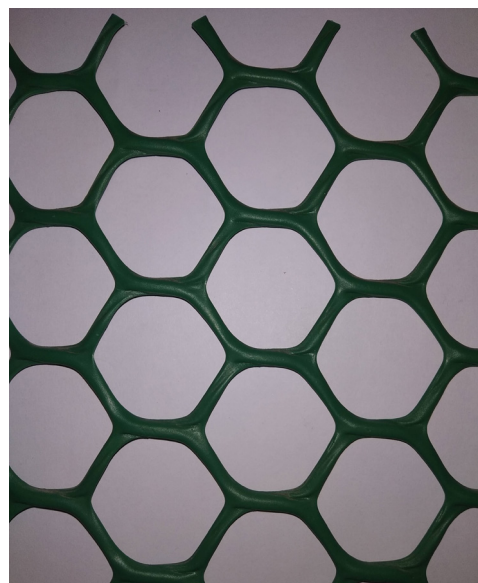


FIG. 1 HEXAGONAL APERTURE

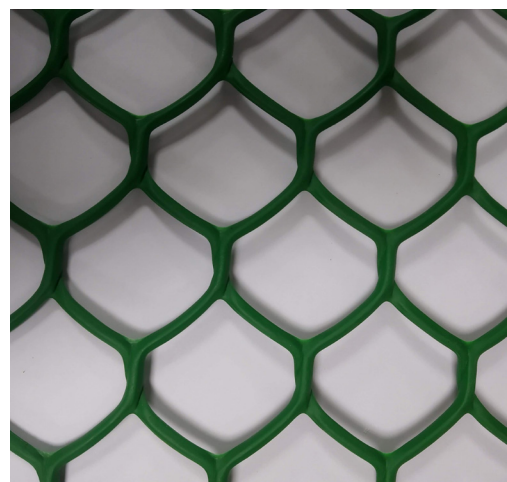


FIG. 2 DIAMOND APERTURE

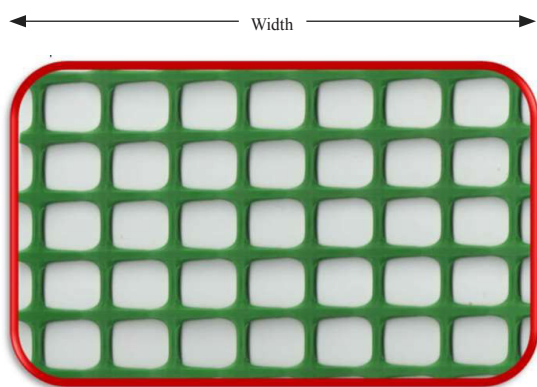


FIG. 3 SQUARE APERTURE

6 TYPES

Based on the application, the fencing nets are classified as follows:

- Light duty,
- Medium duty, and
- Heavy duty.

7 REQUIREMENTS

The fencing nets shall conform to the requirements specified in Tables 1, 2 and 3 for light duty, medium duty and heavy duty fencing nets respectively.

8 PACKING AND MARKING

8.1 Packing

The HDPE fencing nets shall be packed in roll form in length as agreed to between the buyer and the seller.

8.2 Marking

8.2.1 Each fencing net shall be marked legibly by affixing an identification tag/label with the following information:

- Indication of the source of manufacture;
- Type of fencing net;
- Declared length and width of the fencing nets;
- Mass per square meter of the fencing nets;
- Aperture shape and size;
- Batch No. and date of manufacture; and
- Any other information desired by the buyer.

Table 1 Requirements of Light Duty Fencing Nets (Hexagonal Shape)

(Clauses 4 and 7)

Sl No.	Characteristics	GSM of Fencing Nets				Tolerances	Method of Test, Ref to
		450	500	550	650		
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)
i)	Mass, g/m ²	450	500	550	650	± 5 percent	IS 1964
ii)	Mesh size, machine direction, mm	27	25	27	25	± 2 mm	Annex B
iii)	Mesh size, transverse direction, mm	28	28	28	28	± 2 mm	Annex B
iv)	Thickness at joint, mm	4	4.8	5	5.3	± 10 percent	Annex B
v)	Filament thickness, mm	2.1	2.3	2.4	2.6	± 10 percent	Annex B
vi)	Dimensions (length and width)	As declared + 1 percent with no negative tolerance				—	Annex B
vii)	Tensile strength before UV exposure, kN/m, <i>Min</i> :					—	Annex C
	a) Machine direction	4	5	5	6		
	b) Transverse direction	3.5	4	4	5		
viii)	Elongation before UV exposure, percent, <i>Min</i> :					—	Annex C
	a) Machine direction	← 250 percent →					
	b) Transverse direction	← 250 percent →					
ix)	Tensile strength after UV exposure of 144 h, kN/m, <i>Min</i> :					—	Annex D
	a) Machine direction	85 percent of the actual original value					
	b) Cross machine direction	85 percent of the actual original value					

Table 2 Requirements of Medium Duty Fencing Nets (Square Shape)
(Clauses 4 and 7)

SI No.	Characteristics	GSM of Fencing Nets	Tolerances	Method of Test, Ref to
(1)	(2)	500	(4)	(5)
i)	Mass, g/m ²	500	± 5 percent	IS 1964
ii)	Mesh size, Machine direction, mm	20	± 2 mm	Annex B
iii)	Mesh size, Transverse direction, mm	20	± 2 mm	Annex B
iv)	Thickness at joint, mm	2.2	± 10 percent	Annex B
v)	Filament thickness, mm	1.8	± 10 percent	Annex B
vi)	Dimensions (length and width)	As declared + 1 percent with no negative tolerance	—	Annex B
vii)	Tensile strength before UV exposure, kN/m, <i>Min</i> :		—	Annex C
	a) Machine direction	45		
	b) Transverse direction	30		
viii)	Tensile strength after UV exposure of 144 h, kN/m, <i>Min</i> :		—	Annex D
	a) Machine direction	85 percent of the actual original value		
	b) Cross machine direction	85 percent of the actual original value		

Table 3 Requirements of Heavy Duty Fencing Nets (Diamond Shape)
(Clauses 4 and 7)

SI No.	Characteristics	GSM of Fencing Nets			Tolerances	Method of Test, Ref to
(1)	(2)	500	820	840	(6)	(7)
i)	Mass, g/m ²	500	820	840	± 5 percent	IS 1964
ii)	Mesh size, machine direction, mm	40	55	64	± 2 mm	Annex B
iii)	Mesh size, transverse direction, mm	40	55	62	± 2 mm	Annex B
iv)	Thickness at joint, mm	5.7	7.4	8.5	± 10 percent	Annex B
v)	Filament thickness, mm	3.9	4.2	4.5	± 10 percent	Annex B
vi)	Dimensions (length and width)	As declared + 1 percent with no negative tolerance			—	Annex B
vii)	Tensile strength before UV exposure, kN/m, <i>Min</i> :				—	Annex C
	a) Machine direction	6	5	6		
	b) Transverse direction	5.5	4	4		
viii)	Tensile strength after UV exposure of 144 h, kN/m, <i>Min</i> :				—	Annex D
	a) Machine direction	85 percent of the actual original value				
	b) Cross machine direction	85 percent of the actual original value				

8.2.2 BIS Certification Marking

The fencing net rolls conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the fencing net rolls may be marked with the Standard Mark.

9 SAMPLING**9.1 Lot**

All HDPE fencing net rolls/bundles of same type and construction dispatched to a buyer against one dispatch note shall constitute a lot.

9.2 Unless otherwise agreed to between the buyer and the seller, the number of HDPE fencing net rolls/bundles to be selected at random from a lot shall be as given in column 3 of Table 4.

10 NUMBER OF TEST SPECIMENS AND CRITERIA FOR CONFORMITY

Number of test specimens and criteria for conformity shall be as given in Table 5.

Table 4 Scale of Sampling
(Clause 9.2)

SI No.	No. of Rolls/Bundles in Lot	Sample Size	Sub-Sample Size	Permissible No. of Defective Rolls/Bundles
(1)	(2)	(3)	(4)	(5)
i)	Up to 50	3	2	0
ii)	51 - 150	5	2	0
iii)	151 - 300	8	3	1
iv)	301 - 500	13	5	2
v)	501 and above	20	5	3

Table 5 Number of Test Specimens and Criteria for Conformity
(Clause 10)

SI No.	Characteristic	No. of Rolls/Bundles	Criteria for Conformity
(1)	(2)	(3)	(4)
i)	Material, manufacture, mass, mesh size, thickness and dimensions	According to column 3 of Table 4 in column 5 of Table 4	The defective rolls do not exceed the corresponding number given
ii)	All other requirements	According to column 4 of Table 4	All the test specimens shall pass the tests

ANNEX A

(Clause 2)

LIST OF REFERRED INDIAN STANDARDS

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
1964 : 2001	Methods for determination of mass per unit length and mass per unit area of fabrics (<i>second revision</i>)	10146 : 1982	Specification of polyethylene for its safe use in contact to foodstuffs, pharmaceuticals and drinking water
6359 : 1971	Method for conditioning of textiles	16366 : 2015	Glossary of terms used in agrotextile

ANNEX B[Tables 1, 2 and 3, *Sl Nos.* (ii) to (vi)]**METHOD OF TEST FOR MESH SIZE, THICKNESS AT JOINT, FILAMENT THICKNESS AND NET DIMENSIONS****B-1 METHOD OF TEST FOR MESH SIZE**

Mesh size shall be measured from inside to inside with a suitable caliper with an accuracy of 0.02 mm. Test five adjacent mesh each in machine and transverse direction and determine the average mesh size in machine and transverse direction separately.

B-2 METHOD OF TEST FOR THICKNESS AT JOINT AND FILAMENT THICKNESS

Thickness at joint and filament thickness shall be measured with a suitable flat anvil micrometer with an

accuracy of 0.01 mm. Test joint thickness at five points each in machine and transverse direction and take the average of 10 values and report nearest to 0.01 mm. Similarly, test filament thickness at five points each in machine and transverse direction and take the average of 10 values and report nearest to 0.01 mm

B-3 METHOD OF TEST FOR NET DIMENSIONS

Lay each fencing net flat on a table. Render it free from bow and warping and measures the width and length nearest to 1 mm.

ANNEX C[Tables 1, 2 and 3, *Sl No.* (vii) and Table 1, *Sl No.* (viii)]**METHOD OF TEST FOR DETERMINING TENSILE PROPERTIES OF FENCING NETS**

C-1 This test method covers the determination of the tensile properties of fencing nets in the form of rectangular test specimens when tested under defined conditions of temperature, and machine speed.

C-2 APPARATUS

C-2.1 Testing Machine — A testing machine of the constant rate-of-crosshead-movement type and comprising essentially the following:

C-2.1.1 Fixed Member — A fixed or essentially stationary member carrying one grip.

C-2.1.2 Movable Member — A movable member carrying a second grip.

C-2.1.3 Grips — Grips for holding the test specimen between the fixed member and the movable member of the test apparatus can be either a fixed or self-aligning type.

C-2.1.3.1 Fixed grips are rigidly attached to the fixed and movable members of the test apparatus. Extreme care shall be taken when this type of grip is used to ensure that the test specimen is inserted and clamped so that the long axis of the test specimen coincides with the direction of pull through the centerline of the grip assembly.

C-2.1.3.2 Self-aligning grips are attached to the fixed and movable members of the test apparatus. This type of grip assembly is such that they will move freely into alignment as soon as any load is applied as long as the long axis of the test specimen will coincide with the direction of the applied pull through the centerline of the grip assembly. The specimens shall be aligned as perfectly as possible with the direction of pull so that no rotary motion will occur in the grips thereby inducing slippage; there is a limit to the amount of misalignment self-aligning grips will accommodate.

C-2.1.4 *Drive Mechanism*

A drive mechanism for imparting to the movable member a uniform, controlled velocity with respect to the stationary member, with this velocity to be regulated as specified in **C-3.1**.

C-2.1.5 *Load Indicator*

A suitable load-indicating mechanism capable of showing the total tensile load carried by test specimen when held by the grips. This mechanism shall essentially free of inertia lag at the specified rate of testing and shall indicate the load with an accuracy of ± 1 percent of indicated value, or better.

C-3 TEST SPECIMENS AND TEST SPEED

C-3.1 Cut the specimen of size 350 mm length. The width of the specimen shall be such that minimum two complete apertures in machine or transverse direction shall be ensured. The tensile test shall be carried out using gauge length of 200 mm and cross head speed of 100 mm/min.

C-3.2 All surfaces of the specimen shall be free of visible flaws, scratches, or imperfections. If the specimen exhibits such markings, it shall be discarded and replaced.

C-4 TEST CONDITION

Prior to the test, specimens shall be conditioned to moisture equilibrium from dry side in standard atmosphere of 65 ± 5 percent relative humidity and $27 \pm 2^\circ\text{C}$ temperature as laid down in IS 6359.

C-5 NUMBER OF TEST SPECIMENS

Test at least five specimens in machine and transverse direction.

C-6 PROCEDURE

C-6.1 Place the specimen in the grips of the test apparatus taking care to align the long axis of the specimen and the grips with an imaginary line joining the points of attachment of grips to the machine. Tighten the grips evenly and firmly to degree necessary to prevent slippage of the specimen during the test, but not to the point where the specimen would be crushed.

C-6.2 Set the speed of testing at the proper rate in accordance with **C-3.1**, and start the machine.

C-6.3 Record the load-extension curve of the specimen. Record the load and extension at the moment of rupture point.

C-7 CALCULATION

C-7.1 Tensile Strength

Calculate the load corresponding to the point of rupture (break), in N. Divide that load by the original minimum width of the specimen, in mm. Express the result, in KN/m, and report it to three significant figures as tensile strength.

C-7.2 Percent Elongation

Calculate percent elongation at the break point by reading the extension (change in gauge length) at the moment the applicable load is reached. Divide that extension by the gauge length for break and multiply by 100. Report percent elongation to the nearest 1 percent.

C-7.3 Calculate the average of the five specimens in each direction for the test results listed in **C-7.1** and **C-7.2**.

ANNEX D

[Table 1, Sl No. (ix) and Tables 2 and 3, Sl No. (viii)]

UV RESISTANCE TEST

D-1 To determine the effect of UV radiation and weathering on the tensile strength, the HDPE fencing nets shall be exposed as given in **D-2** and **D-3**.

D-2 TEST CONDITION

The test shall be carried out with fluorescent UV- lamp Type B (313 nm or its equivalent).

The duration of the test shall be 144 h (that is, six days) in continuous mode.

The test cycle shall be: 8 h at $60 \pm 3^\circ\text{C}$ with UV-radiation alternating with 4 h at $50 \pm 3^\circ\text{C}$ with condensation. Irradiance level throughout the test shall be maintained at $0.63 (+0.03/-0) \text{ W/m}^2$.

D-3 TEST PROCEDURE

D-3.1 Determine the original average tensile strength of fencing nets as per the test method specified in Annex C.

D-3.2 Expose the specimens alternately to ultraviolet light and condensation in respective test cycle in continuous mode for total 144 h.

The type of fluorescent UV-lamp, the timing of the UV and condensation exposure and the temperature of the UV exposure and condensation shall be as specified in **D-2**.

D-3.3 Determine the average tensile strength of the fencing nets separately after UV exposure as mentioned above.

D-3.4 Determine the percent retention of original strength as follows:

Retention of original tensile strength, percent = $\frac{b}{a} \times 100$
where,

a = Average tensile strength before UV exposure as obtained in **D-3.1**, and

b = Average tensile strength after UV exposure as obtained in **D-3.3**.

NOTES:

1 The UV source is an array of fluorescent lamps (with lamp emission concentrated in the UV range).

2 Condensation is produced by exposing the test surface to a heated, saturated mixture of air and water vapors, while the reverse side of the test specimen is exposed to the cooling influence of ambient room air.

ANNEX E

(Foreword)

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BUREAU OF INDIAN STANDARDS

Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002

Telephones: 2323 0131, 2323 3375, 2323 9402

Website: www.bis.gov.in

Regional Offices:

Telephones

Central	: Manak Bhavan, 9 Bahadur Shah Zafar Marg NEW DELHI 110002	{ 2323 7617 2323 3841
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